

SPLC

Date: Tuesday, 12/18/2007 10:46:07 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 36400 -1		Part Number	: D3183044	
Estimate Number	: 10291		Drawing Number	: D3183 REV C1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/18/2007 S.O. No. : N/A		Drawing Revision	: C1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/12/2008	
Previous Run	: 34514		Qty:	8 Um: Each	
Written By	: KJ/07.12.18				
Checked & Approved By					
Comment	: Est Rev: Pick:A 04.02.18 New issue KJ/DS				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M174B2000X01500	17-4 SS Bar	
Comment: Qty.: 0.4812 f(s)/Unit Total : 3.8497 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.500x02.000) Identify for D3183-4 Batch: 11478			
2.0	BAND SAW	BAND SAW	
Comment: BAND SAW Cut blanks: (1.500" x 2.000") 5.500" long			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3183-4 as per Folio FA322 and Dwg D3183 Identify as D3183-4 2-Deburr 3-Scribe batch number			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/18/2007 10:46:07 AM
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Drawing Name: BRACKET ASSEMBLY

Job Number: 36400

Part Number: D3183044

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08/01/14

6.0 D312121 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3121-21 Bolt 1336608

SD 08/01/14

7.0 D3183045 Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3183-045 Bearing Ass 1336369

SD 08/01/14

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3183-043 as per Dwg D3183.

SD 08/01/14

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 08/01/14 (3)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12/18/14 (3)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 08/01/14 (3)

Job Completion



SD 08/01/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36400
Description: Bracket		Part Number:	D3183-4
Inspection Dwg: D3183	Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.190	/			
R0.063	+/-0.010	R.063	/			
0.182	+/-0.010	.181	/			
0.070	+/-0.010	.070	/			
0.100	+/-0.010	.106	/			
Ø0.201 x 0.100	+/-0.010	Ø200x099	/			
0.182	+/-0.010	.181	/			
5.32	+/-0.030	5.327	/			
5.036	+/-0.010	5.036	/			
2.120	+/-0.010	2.120	/			
1.290	+/-0.010	1.288	/			
0.365	+/-0.010	.367	/			
0.218	+/-0.010	.216	/			
1.030	+/-0.010	1.040	/			
1.90	+/-0.030	1.890	/			
1.012	+/-0.010	1.012	/			
Ø0.201 x 0.100	+/-0.010	Ø200x100	/			
0.182	+/-0.010	.182	/			
0.786	+/-0.010	.786	/			
Ø0.392	+0.002/-0.000	Ø393	/			
R0.19	+/-0.030	R.190	/			
3.954	+/-0.010	3.955	/			
0.162	+/-0.010	.162	/			
R0.19	+/-0.030	R.190	/			
R0.25	+/-0.030	R.25	/			
4.26	+/-0.030	4.265	/			
2.800	+/-0.030	2.800	/			
Calculated dimension						
0.162	+/-0.010	.162	/			
0.615	+/-0.010	.615	/			
0.435	+/-0.010	.435	/			
0.200	+/-0.010	.200	/			
0.381	+/-0.010	.385	/			
0.032	+/-0.010	.032	/			

Measured by:	SD	Audited by:	RF	Prototype Approval:	N/A
Date:	08/01/12	Date:	08/1/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	SD

DART

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02

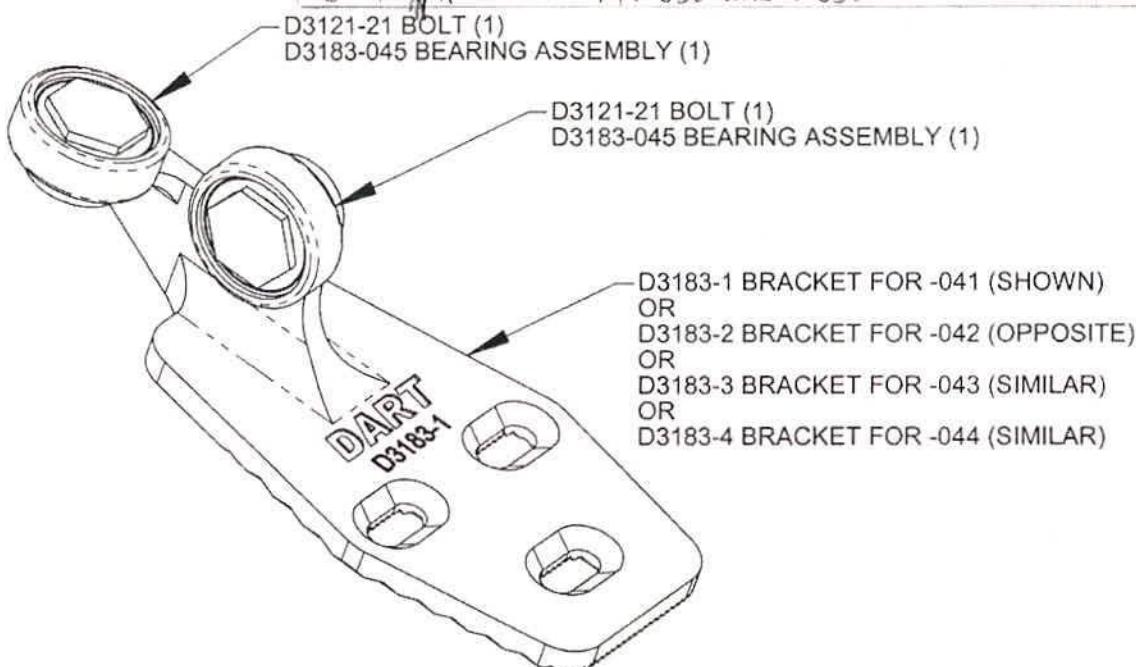
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CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 1 OF 4

DATE 04.02.17 TITLE SCALE 1:1

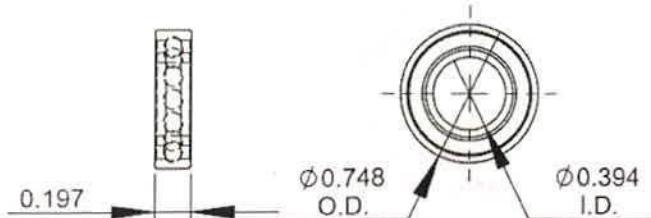
BRACKET ASSEMBLY

A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045-9; 0.182 WAS 0.431
C1	04.11.07	0-830 WAS 0.850

RELEASED
04.03.01



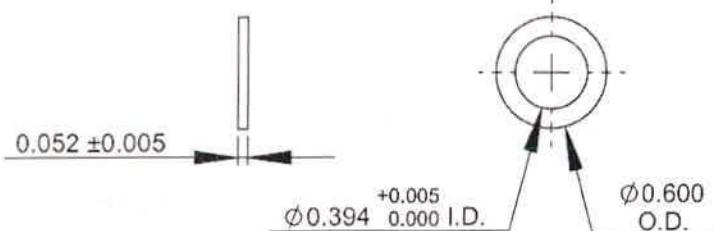
D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



**D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING**

1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
 3) ALL DIMENSIONS ARE IN INCHES

RETURN TO
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WORK ORDER
NO. 36400



D3183-7 WASHER

1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
 3) TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES

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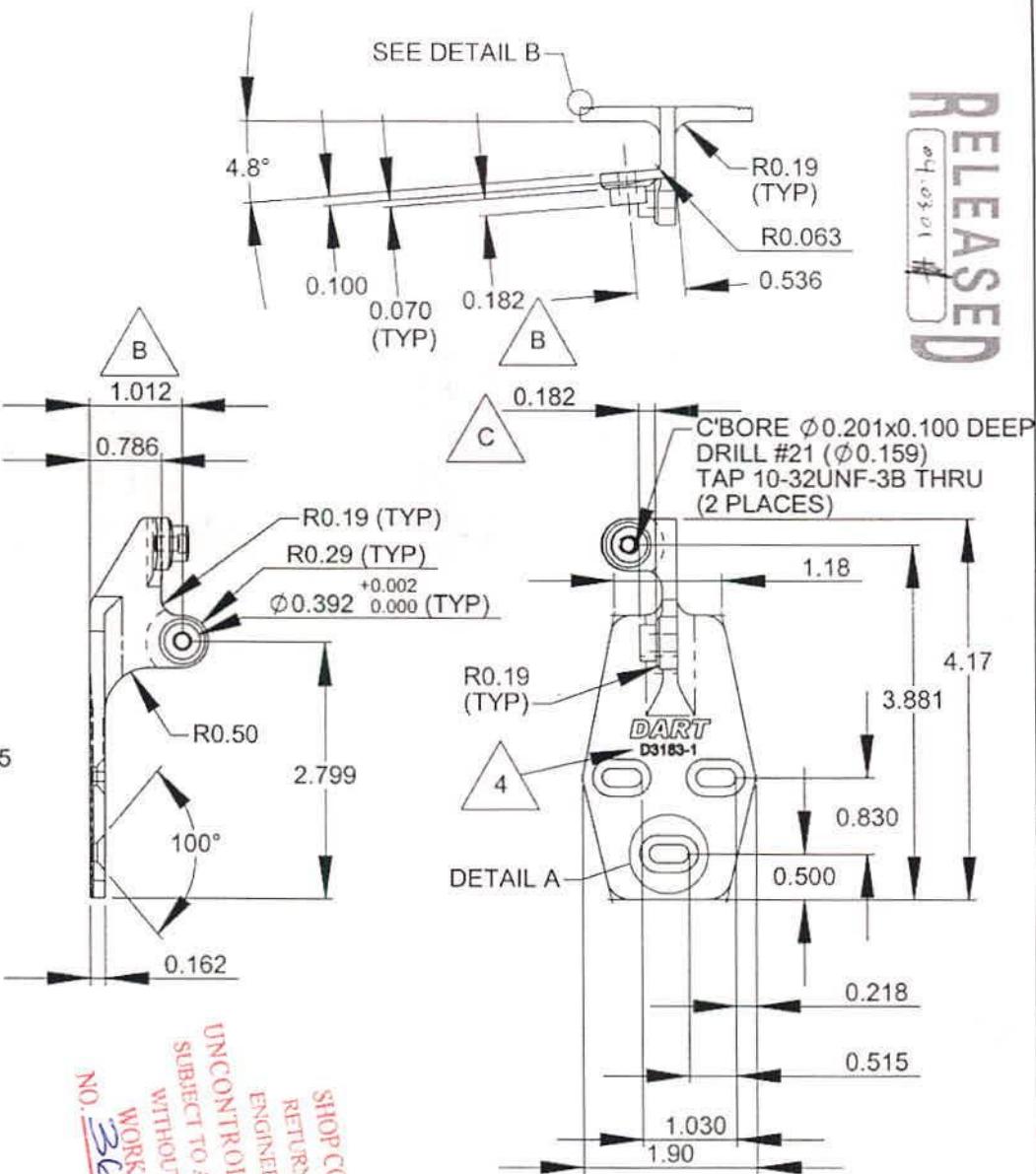
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CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3183
DATE	04.02.17	TITLE
		BRACKET ASSEMBLY
		SHEET 2 OF 4
		SCALE
		1:2

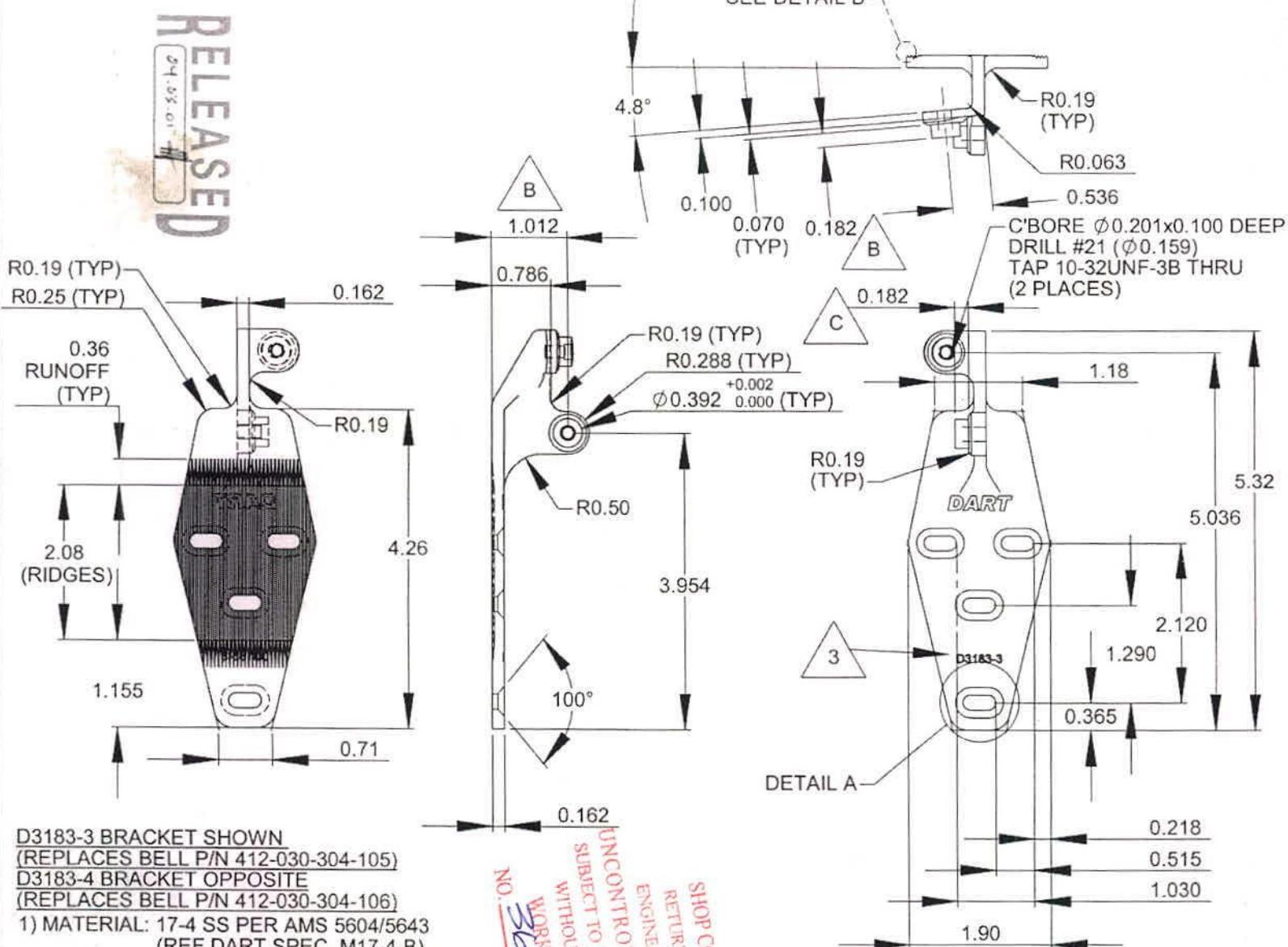
D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI.018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



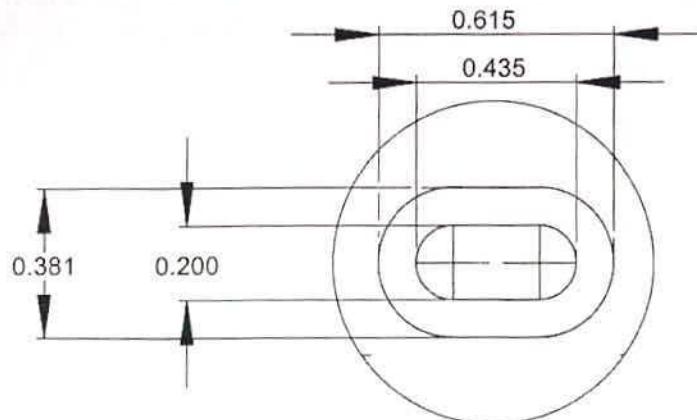
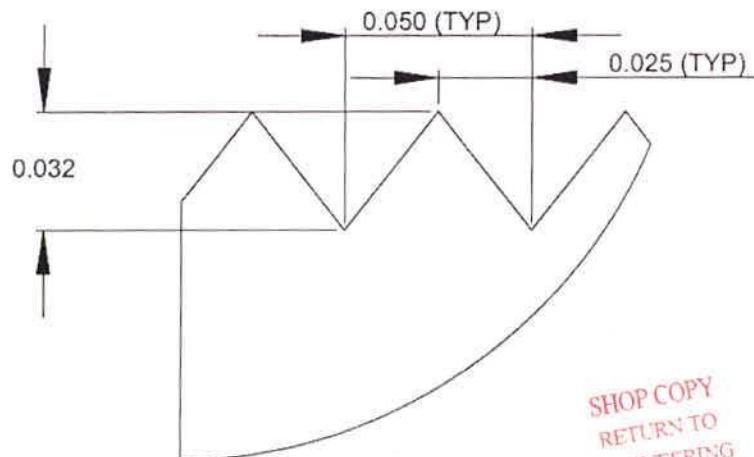
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CHECKED	APPROVED	DRAWING NO. D3183
DATE	04.02.17	TITLE BRACKET ASSEMBLY
		REV. C SHEET 3 OF 4 SCALE 1:2

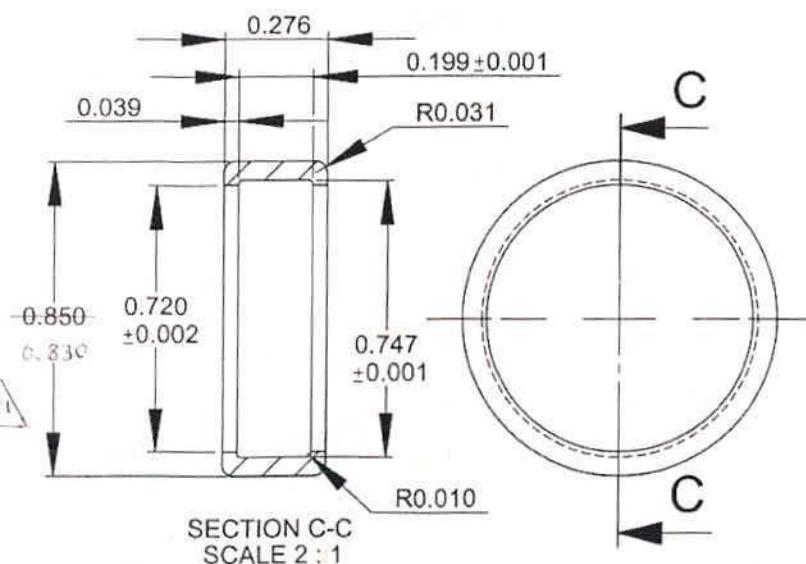


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10

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DATE	04.02.17	D3183	SHEET 4 OF 4

TITLE
BRACKET ASSEMBLYSCALE
1:1DETAIL A (2 : 1)**RELEASED**
04.03.01DETAIL B (20 : 1)

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WITHOUT NOTICE
WORK ORDER
NO. 36400

SECTION C-C
SCALE 2 : 1**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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